

# NEEGINAN INSTITUTE OF APPLIED TECHNOLOGY WINNIPEG, MANITOBA

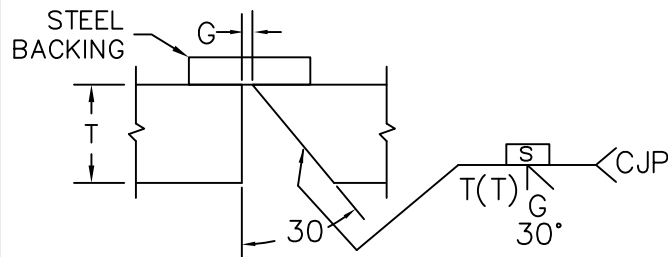
NO.	CS-M-4-1V	REV.	1
Date:	JAN 2010	CSA	W47.1

## WELDING PROCEDURE DATA SHEET

Wdg. Procedure Specification No.	SMA-CS
Applicable Standards	W47.1, W59
Electrode (Wire) Classification	E4918/E7018
Trade Name	
Shielding Gas	
Preheat Temp.	AS PER W59 TABLE 5.3
Min. Interpass Temp.	AS PER W59 TABLE 5.3
Max. Interpass Temp.	500°F

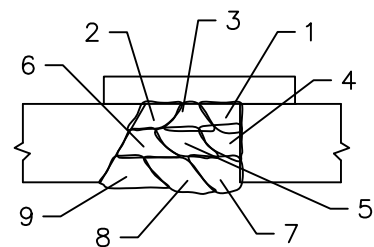
Welding Process <input checked="" type="checkbox"/> Shielded Metal (SMAW) <input type="checkbox"/> Flux Core (FCAW) <input type="checkbox"/> Metal Core (MCAW) <input type="checkbox"/> Submerged (SAW)	<input type="checkbox"/> Gas Metal (GMAW) <input type="checkbox"/> Gas Tungsten (GTAW) <input type="checkbox"/> Pulsed <input type="checkbox"/> Pulsed	Tungsten Type  Tungsten Size  Welding Position VERTICAL UP
Process Mode <input checked="" type="checkbox"/> Manual <input type="checkbox"/> Machine <input type="checkbox"/> Semi-Automatic <input type="checkbox"/> Automatic	Base Metal Alloy Group/Type STEEL GROUPS, 1,2 &3 TABLES 11.1 & 12.1 CSA W59	Cleaning Requirements WIRE BRUSH

PREQUALIFIED PER CSA W59, M4-2



Rf=0"  
G=1/2"

TYPICAL JOINT PREPARATION



TYPICAL PASS AND LAYER SEQUENCE

COMPLETE JOINT PENETRATION GROOVE WELD <input type="checkbox"/> Welded onto temporary backing <input checked="" type="checkbox"/> Welded onto permanent backing <input type="checkbox"/> Welded with no backing <input type="checkbox"/> Back-gouged to sound metal				<input type="checkbox"/> FILLET WELD  <input type="checkbox"/> PARTIAL JOINT PENETRATION GROOVE WELD  <input type="checkbox"/> OTHER _____			JOINT TYPE <input checked="" type="checkbox"/> BUTT <input type="checkbox"/> CORNER <input type="checkbox"/> LAP <input type="checkbox"/> TEE <input type="checkbox"/> EDGE		Nozzle Size	Shielding Gas	Electrical Stickout
Mat'l Thk.	Weld Size/ETT	Layer No.	Pass No.	Filler Dia. (inches)	Current Polarity	Current (Amps) ±10%	Wire Feed Speed (IPM) ±10%	Voltage (Volts) ±10%	Welding Speed (IPM) ±10%	Heat Input (joules)	Other
5/16"	5/16"	1-3	1-9	1/8"	DCRP	110		24	4 IPM		
3/8"	3/8"	1-3	1-9	1/8"	DCRP	110		24	4 IPM		

Remarks	CWB Acceptance	Engineer's Approval
REV 1 GENERAL REVISIONS		

SAMPLE